

Work Order ID 85996-2

June-19-12 12:02:03 PM

85996

Page 1

Item ID: D3183-044

Revision ID:

Item Name: Bracket Assembly

Start Date: 19/06/2012 Start Qty: 6.00

Required Date: 03/07/2012 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

Date: 12/06/19

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3183

Rev C1

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.500" x 2.250") 5.500" long

PO 12/07/19 12 Ø

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

I-Machine D3183-4 as per Folio FA322 and Dwg D3183Identify as D3183-42-Debur3-Scribe batch number

FK 12/07/23 29 27.25

11 Ø

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

FK 12/07/23 29 27.25

11 Ø

Work Order ID 85996

June-19-12 12:02:03 PM

85996

Page 2

Item ID: D3183-044

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 19/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Assemble D3183-043 as per Dwg D3183.

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

12/07/30

11

MF 12-08-10
Sign for E.B.

DAS
16
9-83
12/08/10

410

21

Work Order ID 85996

June-19-12 12:02:03 PM

85996

Page 3

Item ID: D3183-044

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 19/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Identify as per dwg & Stock Location

236B

0.00

160

Packaging

Memo

0.00

Packaging

C 12/08/10

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/8/13

mf 12-08-10

Picklist Print

June-19-12 12:02:07 PM

Page 1

Work Order ID: 85996

85996

Parent Item: D3183-044

D3183-044

Parent Item Name: Bracket Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:Pick:A04.02.18New issueKJ/DS

IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3183-045

Manufactured

No

100

Each

26.0000

2

12

**

D3183-045

Bearing Assembly

Location

Loc Qty

Loc Code

ST236

26

77830

1

79697

4

80903

21

D3121-21

Manufactured

No

140

Each

95.0000

2

12

**

D3121-21

Bolt

Location

Loc Qty

Loc Code

ST235

95

66969

1

79732

4

83364

11

85332

19

85660

60

M174B1.500X02.250

Purchased

No

140

f

22.8479

0.4583

2.894526

**

M174B1 500X02 250

17-4 SS Bar 1.50 X2.250

Location

Loc Qty

Loc Code

MAT031

22.8479

108309

1.08

113568

11.8333

115806

3.0846

→ 121026

6.85

PO 12/07/19

6.85

DART AEROSPACE LTD		Work Order:	85996
Description: Bracket		Part Number:	D3183-4
Inspection Dwg: D3183	Rev: C1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	.190	✓		FK-04	Vern. rad gauge
R0.063	+/-0.010	.063	✓		rad gauge	"
0.182	+/-0.010	.190	✓		FK-04	Vern.
0.070	+/-0.010	.070	✓		"	"
0.100	+/-0.010	.099	✓		"	"
Ø0.201 x 0.100	+/-0.010	Ø.200 x .106	✓		"	"
0.182	+/-0.010	.189	✓		"	"
5.32	+/-0.030	5.333	✓		31006	Height gauge
5.036	+/-0.010	5.040	✓		"	"
2.120	+/-0.010	2.120	✓		FK-04	Vern.
1.290	+/-0.010	1.290	✓		"	"
0.365	+/-0.010	.369	✓		"	"
0.218	+/-0.010	.218	✓		"	"
1.030	+/-0.010	1.032	✓		"	"
1.90	+/-0.030	1.90	✓		"	"
1.012	+/-0.010	1.008	✓		"	"
Ø0.201 x 0.100	+/-0.010	Ø.200 x .106	✓		"	"
0.786	+/-0.010	.781	✓		"	"
Ø0.392	+0.002/-0.000	.3929	✓		FK-01	Mic.
R0.19	+/-0.030	.190	✓		rad gauge	"
3.954	+/-0.010	3.958	✓		31006	Height gauge
0.162	+/-0.010	.161	✓		FK-04	Vern.
R0.19	+/-0.030	.190	✓		rad gauge	"
R0.25	+/-0.030	.25	✓		"	"
4.26	+/-0.030	4.273	✓		FK-04	Vern.
2.800	+/-0.030	2.800	✓		FK-04	Vern.
Calculated dimension					FK-04	Depth gauge
0.162	+/-0.010	.163	✓		FK-04	Vern.
0.615	+/-0.010	.618	✓		"	"
0.435	+/-0.010	.431	✓		"	"
0.200	+/-0.010	.200	✓		"	"
0.381	+/-0.010	.381	✓		"	"
0.032	+/-0.010	.031	✓		FK-06	Depth gauge

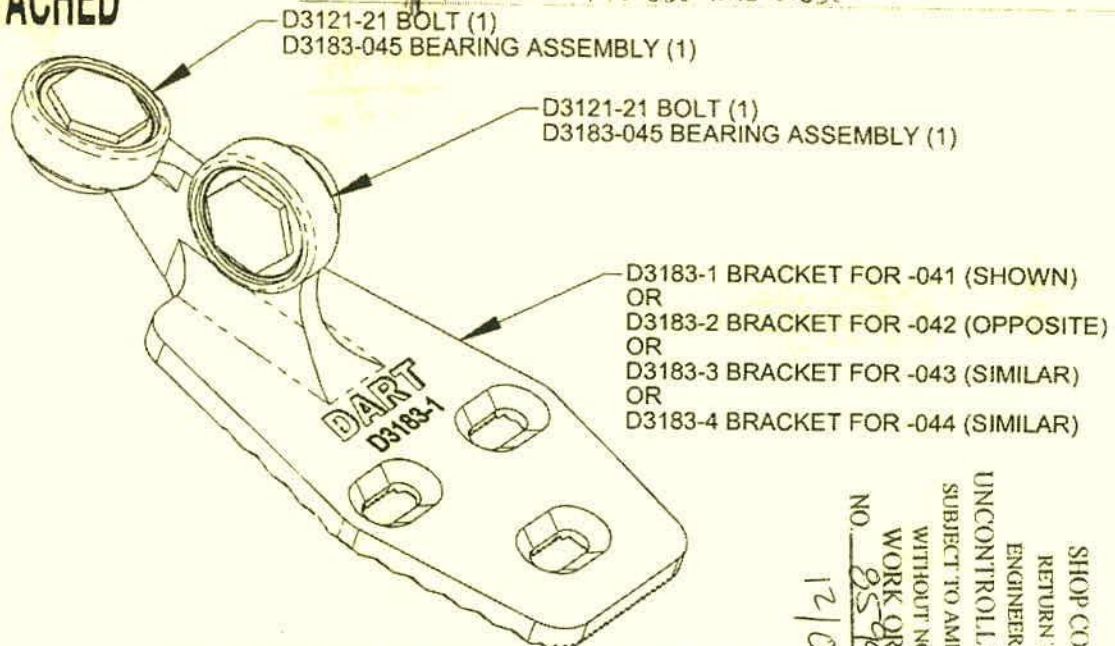
Measured by: FK	Accepted by: BA	Preliminary Approval:	N/A
Date: 12/07/23	Date: 12/07/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	
E	08.01.16	Dimensions revised	KJ/EC/DD	
F	10.09.23	Dimensions revised	KJ	

DART

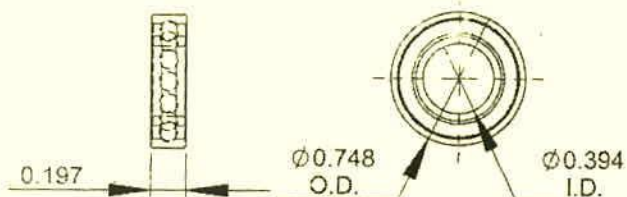
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	04.11.07	0.830 WAS 0.850	

RELEASED
04 03 01
DEO ATTACHED



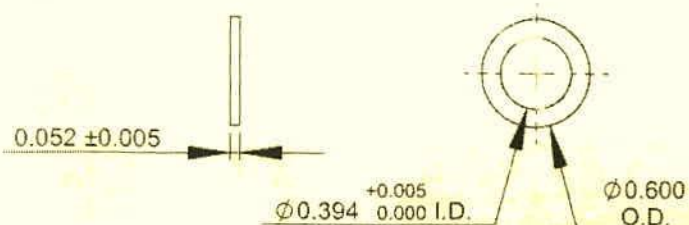
D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85996 MJS
12/06/19



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2003 BY DART AEROSPACE LTD.

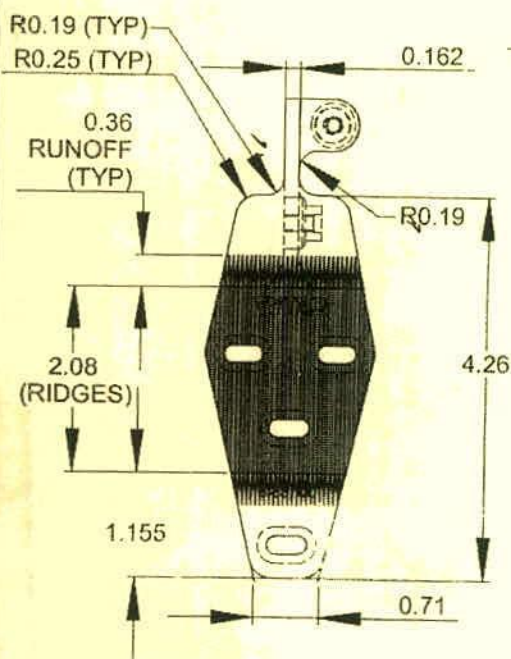
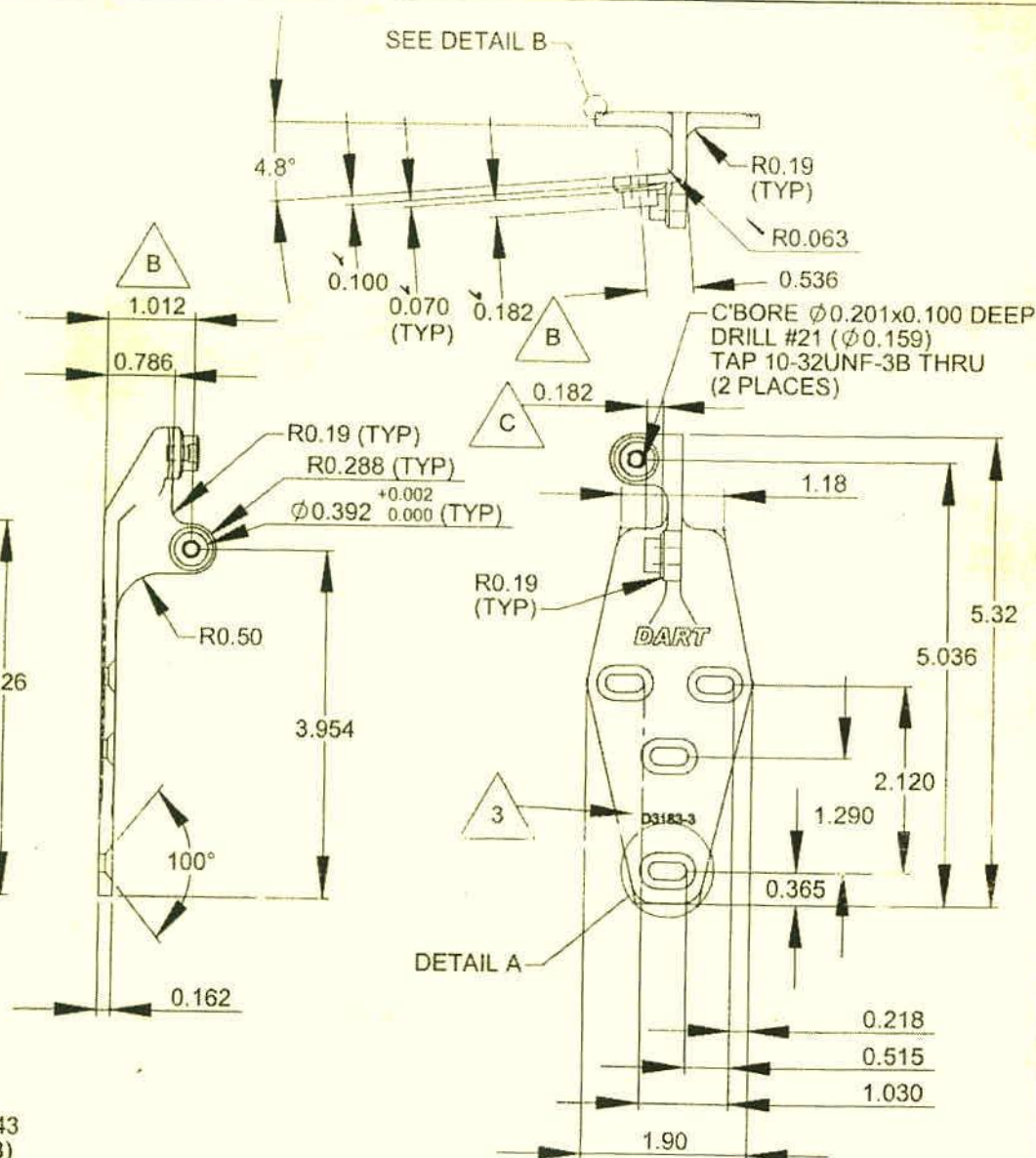
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 2 OF 4
DATE		TITLE	SCALE
04.02.17		BRACKET ASSEMBLY	1:2

25996

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 3 OF 4
TITLE	BRACKET ASSEMBLY	SCALE
		1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2003 BY DART AEROSPACE LTD.

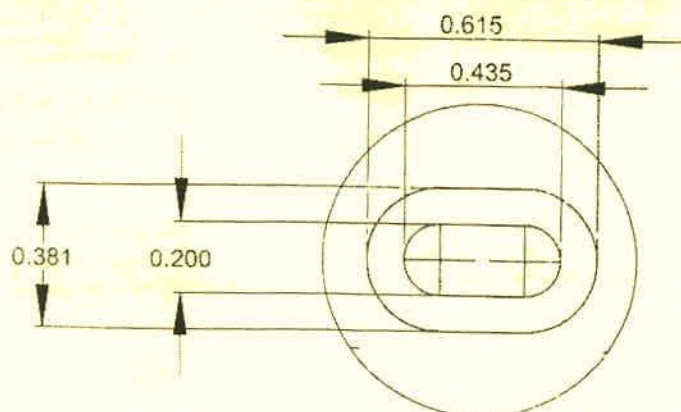
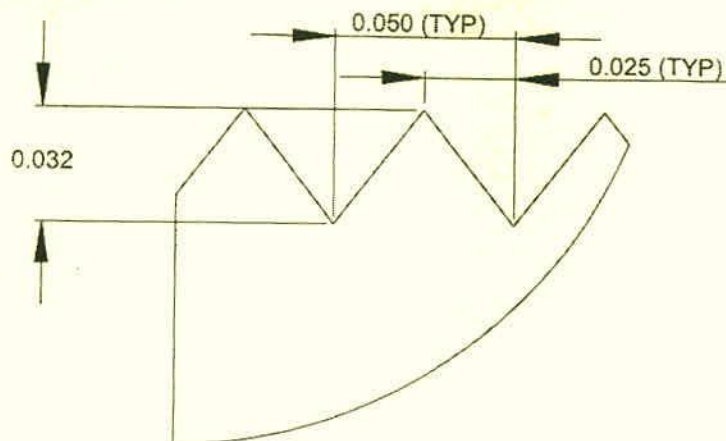
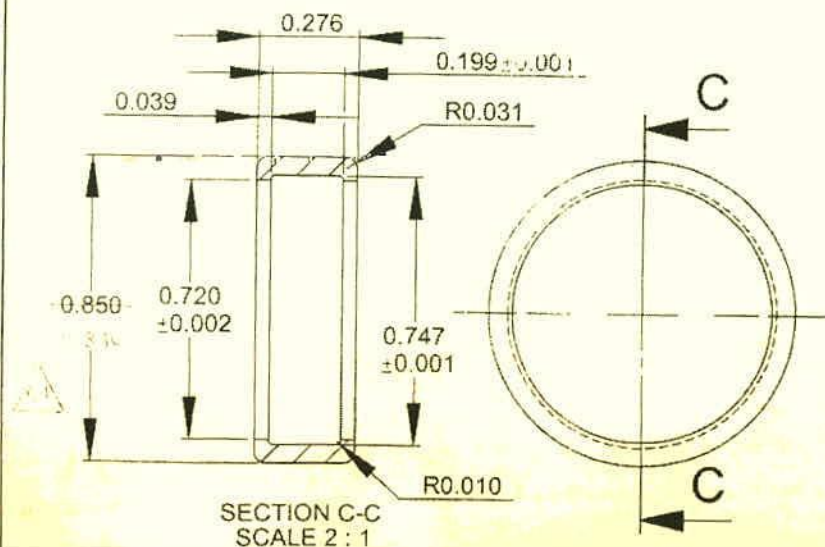
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DEO ATTACHED

RELEASED

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**DETAIL A (2 : 1)****RELEASED**
04 03 21**DEO ATTACHED****DETAIL B (20 : 1)****SECTION C-C
SCALE 2 : 1****D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

COPYRIGHT © 2003 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

05996

25996

DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN qp	CHECKED [Signature]	MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30		DATE 10/06/30		

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

RELEASED
2010-07-22
[Signature]

D3124-141
011 / 34